

40 DART AEROSPACE LTD	Work Order:	21475
Description: 2.750 Support (407 Aft)	Part Number:	D2894-1
Dwg: D2894 Rev. B1	Qty:	14
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller. Blank size makes (2) D2894-1 Dwg not required	KJ	04.09.09	7
2	PG	Issue P/O: <i>pull from B19163</i> Description: D6104-009 Material: 17-4 PH SS (AMS 5643 OR AISI 630) as per Dwg D6104 Material release note required.	W	04.09.15	
3	RG	Receive and inspect for raw material dimensions. Ensure material release note is attached.			
4	MS	Turn blank for Haas as per Folio FA253 <i>B19163</i>	S	04/09/15	
5	QC1	Inspect all dimensions as per Dwg D2894	S	04/09/15	
6	MV	Machine as per Folio FA253	C/S	05.08.29	14
7	MV	Tumble & Deburr	C/S	05.08.31	14
8	QC1	Inspect all dimensions to inspection sheet as per Dwg D2894	C/S	05.08.31	14
9	QC8	Inspect dimensions for second check	W	05/08/31	14
10	FP	Mask Ø0.500" hole prior to paint	M	05.08.31	14
11	FP	Powder Coat White (4.3.5.2) per QSI 005 4.3	M	05.08.31	14
12	QC3	Inspect Powder Coat	C/S	05/09/01	14
13	ST	Identify and stock	C/S	05/09/01	14
14	AC	Cost / part <i>131.68</i>	S	05.09.06	14
15	DC	Close W/O <i>129.72</i> Inspect Level 21	C/S	05/09/02	14

Rev	Date	Change	Revised By	Approved
A	02.06.06	New issue	KJ	
B	02.11.26	Added mask hole	KJ / RF	

RELEASED
02.11.29 RF

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: N/A Fault Category: N/A DQA: LS Date: 25/8/02

DART AEROSPACE LTD	Work Order:	21475
Description: Ø2.750 Support	Part Number:	D2894-1
Inspection Dwg: D2894 Rev. B1		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2894 Rev B1/DSK079 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	2.778	2.783	OK	2.782	2.782	2.782	2.781		
B	3.990	4.010		3.989	3.989	3.989	3.989		
C	3.088	3.108		3.093	3.093	3.093	3.093		
D	0.718	0.738		.726	.724	.733	.726		
E	0.090	0.110		.102	.097	.099	.099		
F	2.968	2.988		2.973	2.976	2.977	2.976		
G	1.410	1.430		1.413	1.417	1.417	1.413		
H	1.150	1.160		1.157	1.157	1.157	1.157		
I	5.240	5.260		5.243	5.249	5.248	5.247		
J	0.022	0.042		.032	.032	.032	.032		
K	0.240	0.260		.250	.250	.250	.250		
L	0.090	0.110		.096	.096	.096	.096		
M									
HAAS Section									
AA	0.454	0.474		.466	.466	0.464	0.470		
AB	3.062	3.082		3.073	3.073	3.071	3.073		
AC	0.053	0.073		.063	.063	0.063	0.063		
AD	0.971	0.991		.983	.983	0.986	0.988		
AE	1.766	1.786		1.778	1.778	1.779	1.776		
AF	0.020	0.040		.030	.030	0.030	0.030		
AG	0.257	0.262	DT8683	.258	.258	0.257	0.257		
AH	0.053	0.073		.063	.063	0.063	0.063		
AI	3.04	3.10		3.061	3.060	3.063	3.058		
AJ	1.990	2.010		1.999	1.999	2.001	2.009		
AK	0.240	0.260		.250	.250	0.250	0.258		
AL	1.884	1.904		1.897	1.897	1.892	1.896		
AM	0.500	0.505	DT8708	.500	.500	0.500	0.500		
AN	0.189	0.194		.189	.190	0.188	0.188		
AO									
AP									
AQ									
AR									
AS									
AT									
AU									
Accept/Reject									

Measured by:	ER (for SP) / SD	Audited by:	ER
Date:	04.10.16 / 05.08.29	Date:	05/08/30

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	RF

DART AEROSPACE LTD	Work Order:	21475
Description: Ø2.750 Support	Part Number:	D2894-1
Inspection Dwg: D2894 Rev. B1		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2894 Rev B1/DSK079 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	2.778	2.783		2.781	2.781	2.780			
B	3.990	4.010		3.994	3.994	3.994			
C	3.088	3.108		3.091	3.091	3.091			
D	0.718	0.738		0.723	0.723	0.725			
E	0.090	0.110		0.094	0.094	0.094			
F	2.968	2.988		2.973	2.973	2.973			
G	1.410	1.430		1.413	1.413	1.413			
H	1.150	1.160		1.157	1.157	1.153			
I	5.240	5.260		5.247	5.247	5.247			
J	0.022	0.042		0.033	0.033	0.033			
K	0.240	0.260		0.250	0.250	0.250			
L	0.090	0.110		0.096	0.097	0.097			
M									
HAAS Section									
AA	0.454	0.474		0.470	0.463	0.466			
AB	3.062	3.082		3.069	3.069	3.073			
AC	0.053	0.073		0.063	0.063	0.063			
AD	0.971	0.991		0.987	0.986	0.986			
AE	1.766	1.786		1.776	1.777	1.779			
AF	0.020	0.040		0.030	0.030	0.030			
AG	0.257	0.262	DT8683	0.257	0.257	0.257			
AH	0.053	0.073		0.063	0.063	0.063			
AI	3.04	3.10		3.060	3.055	3.056			
AJ	1.990	2.010		2.002	2.001	1.999			
AK	0.240	0.260		0.250	0.250	0.250			
AL	1.884	1.904		1.889	1.904	1.903			
AM	0.500	0.505	DT8708	0.500	0.500	0.500			
AN	0.189	0.194		0.188	0.188	0.188			
AO									
AP									
AQ									
AR									
AS									
AT									
AU									
Accept/Reject									

Measured by:	CP
Date:	05/08/31

Audited by:	JML
Date:	05/08/31

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	RF

RELEASED
03.06.18 RF

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 09, 2004
03:16 pm

Work Order No : 0021475
Project Name : D2894-1
Project For : WK440
Work Order Type : Main
Main WO Number :
House Part Number : D2894-1
Description : 2.750 Support
Manufactured : Yes
Amount Req'd : 7
Amount Done : 0
Start Date : 09-09-04
Est Finish Date : 09-30-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00	0.00	0.00
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00	0.00	0.00
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00	0.00	0.00
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00	0.00	0.00
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00	0.00	0.00
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00	0.00	0.00
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00